

# Work Order ID 53045

October 22, 2009 11:26:41 AM



Page 1

Item ID:	D3813-3	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Hinge, Lower Door					
Start Date:	11/10/2009	Start Qty:	6.00	Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>RL</u>	Date:	<u>09-10-22</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3813	Rev A

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 5.725 " long								

M.A 09/11/12

6

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA778 Rev: <u>A</u> & Dwg D3813 Rev: <u>A</u> <input type="checkbox"/> 2-Deburr per dwg D3813 <input type="checkbox"/> 3-Finish tapping hole to final depth as per Dwg D3813								

M.A 09/11/12

5 1

RTO

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

M.A 09/11/12

5 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3813-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>53045</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/12	110	.063 drill broke inside of part. r.e: very fragile drill Process	GP 09.11.17 P- Q81042	SCRAP + Destroy  no Replace	M.A 09/11/17	and 09/11/17	GP 09.11.17 P- Q81042	C 09/11/17

NOTE: Date & initial all entries



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Item ID: D3813-3

Accept

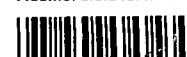


Setup Start



Revision ID: A

Stop



Item Name: Hinge, Lower Door

Start Date: 21/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

br 09-11-17.



QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/11/18

(SVSL)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/18

Br 09-11-18

# Picklist Print

Page 1

October 22, 2009 11:26:45 AM

Work Order ID: 53045



Parent Item: D3813-3RevA



Parent Item Name: Hinge, Lower Door

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg : Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X03.00 0		Purchased	No			100	f	61.8700	3.0316			



6061-T6 Bar .750 x 3.00



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

61.87

104741

30.62

14252

12

15211

19.25

3.000

H.A 09/11/12



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

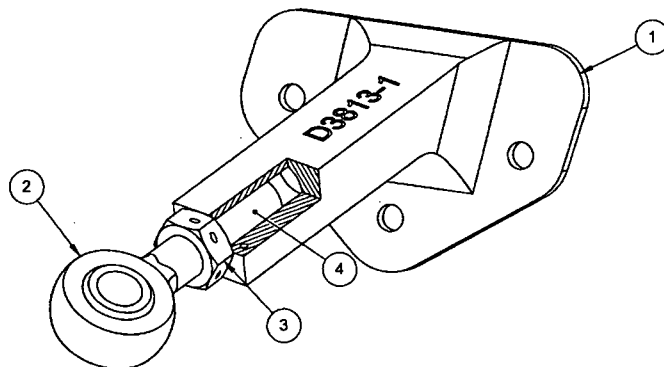
SUBJECT TO AMENDMENT

WITHOUT NOTICE

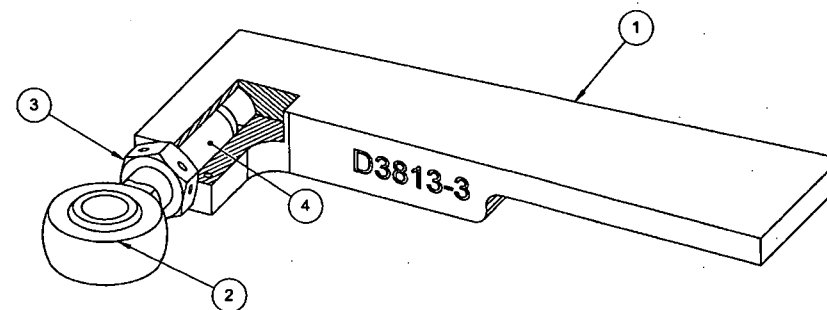
WORK ORDER

NO. 53045

PL 09-0-22



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

**D3813-041 HINGE ASSY, UPPER DOOR**

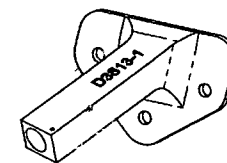
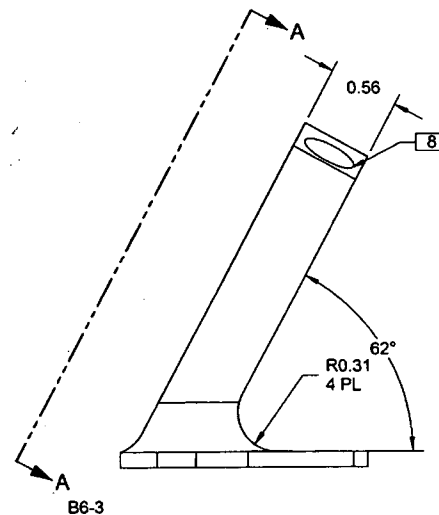
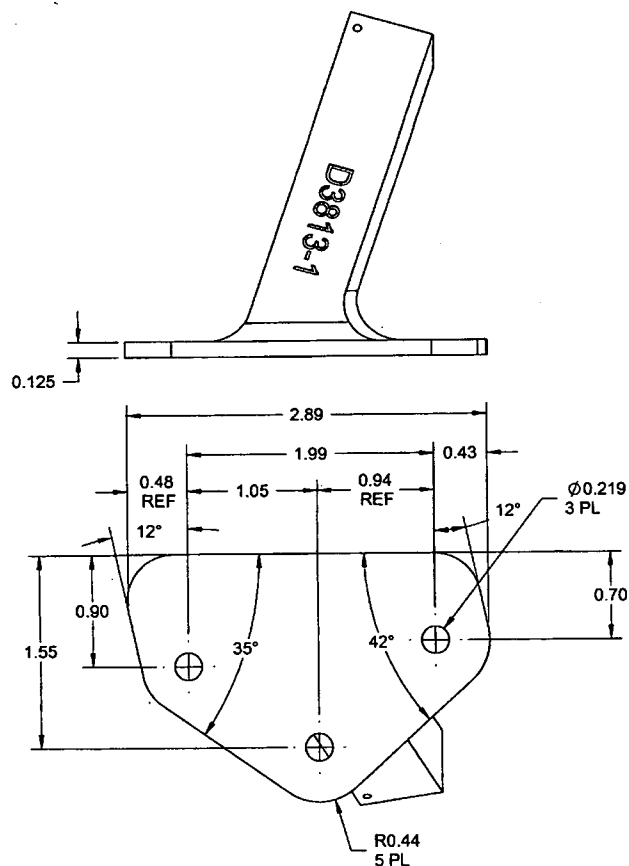
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

**D3813-043 HINGE ASSY, LOWER DOOR**RELEASED  
09/01/13

A	NEW ISSUE	08.11.10
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.11.10	

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3813</b>	REV. A SHEET 1 OF 4
TITLE <b>HINGE</b>	SCALE NTS
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53045



**D3813-1 HINGE, UPPER DOOR**

**NOTES:**

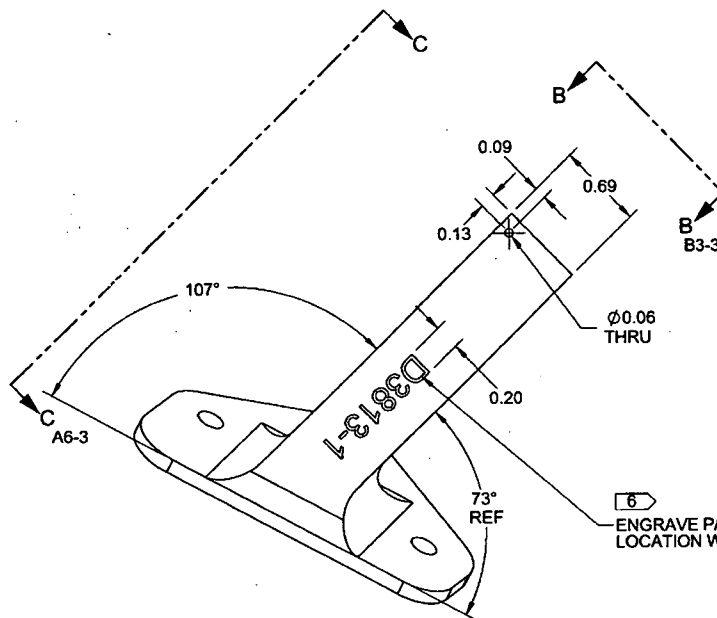
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4180), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.14 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

**RELEASED**  
09/01/13

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3813</b>	REV. A
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE <b>HINGE</b>	SCALE
DE APPR.			NTS
DATE	08.11.10	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

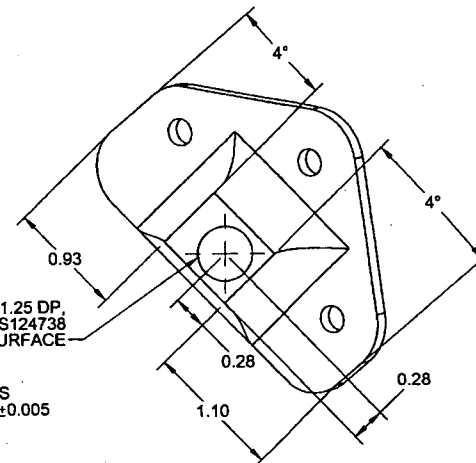
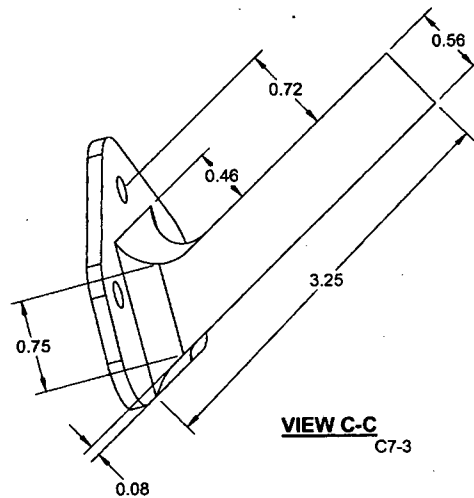


53045

VIEW A-A  
C4-2

Ø0.391 X 1.25 DP,  
INSTALL HELICOIL MS124738  
FLUSH WITH SURFACE

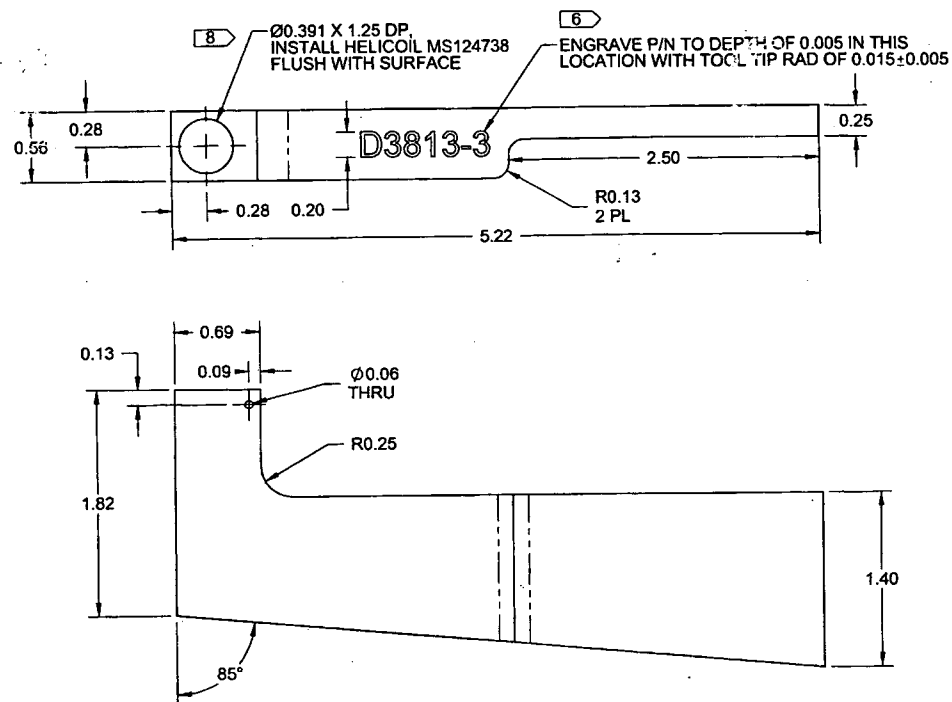
ENGRAVE P/N TO DEPTH OF 0.005 IN THIS  
LOCATION WITH TOOL TIP RAD OF 0.015 ± 0.005

VIEW B-B  
D5-3VIEW C-C  
C7-3**D3813-1 HINGE, UPPER DOOR**

**RELEASED**  
09/01/13

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3813	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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53045



**D3813-3 HINGE, LOWER DOOR**

**RELEASED**  
07/07/12 MJP

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.24 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3813	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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